

Work Order ID 53192

October 26, 2009 11:36:52 AM



Page 1

Item ID: D3186-2M

Accept



Setup Start



Revision ID: E

Stop



Item Name: SPACEPOD DOOR RH

Start Date: 10/26/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/04/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *CZ*

Date: *09/10/26* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3186

Rev E

100

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: *100410* Description: D3186-2MDoor Supplier:
Delastek Conformity Certificate and Process sheet required Ship 3 Items from
Previous steps

CZ 09/10/26

0

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure a copy of certification of conformity and process sheet from Delastek is
attached.

Packaging 0

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Check for void spot and pins.

=> 8/10/27

(K)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 53192

October 26, 2009 11:36:52 AM



Page 2

Item ID: D3186-2M
Revision ID: E
Item Name: SPACEPOD DOOR RH

Accept



Setup Start



Stop



Start Date: 10/26/09 Start Qty: 1.00
Required Date: 11/04/09 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location:

composites

0.00



Packaging

Memo

0.00

Packaging

RT 10-02-22 (x1)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/23
MF 10-2-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

October 26, 2009 11:36:52 AM

Page 1

1

Work Order ID: 53192

Parent Item: D3186-2MRevE

Parent Item Name: SPACEPOD DOOR RH



Comments:

Start Date: 10/26/09

Required Date: 11/04/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|-----------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|-------------------------------------------------------------------------------------|----------------|--------|
| D3186-2PRevE | | Purchased | No | | | 100 | Each | 0.0000 | 1.0000 | | | |
|  | | | | | | | | | |  | | |
| Spacepod Door | | | | | | | | | | | | |

ME
10-2-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

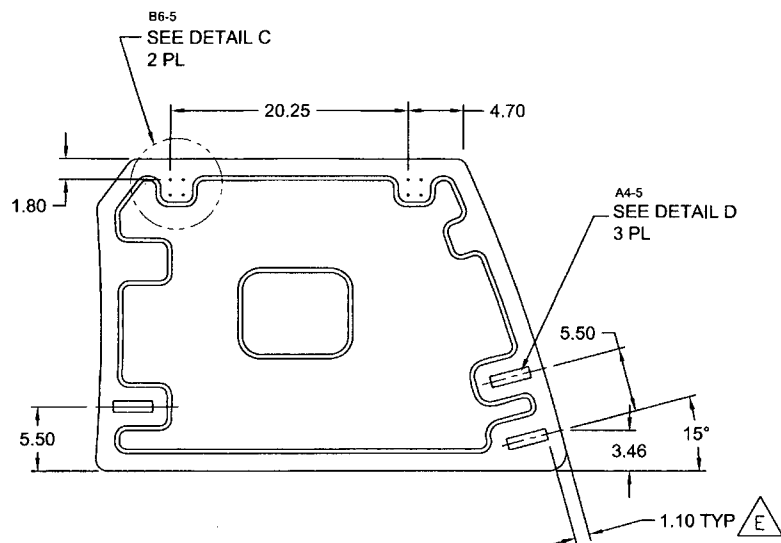
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

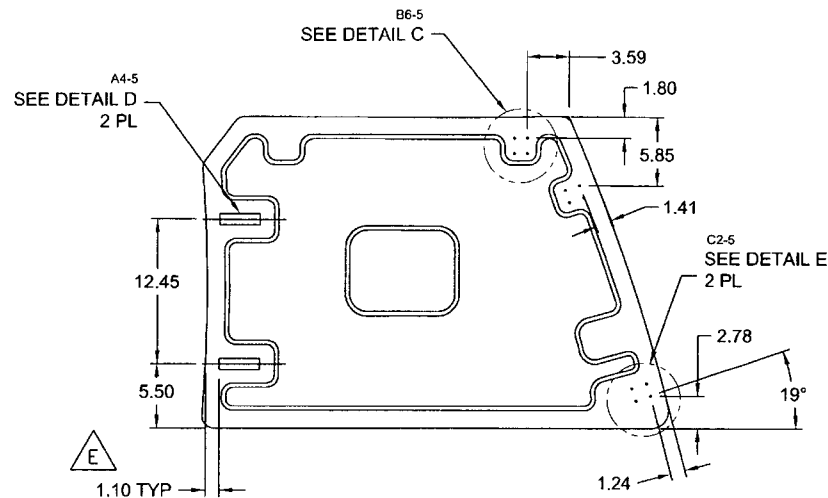
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M







D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

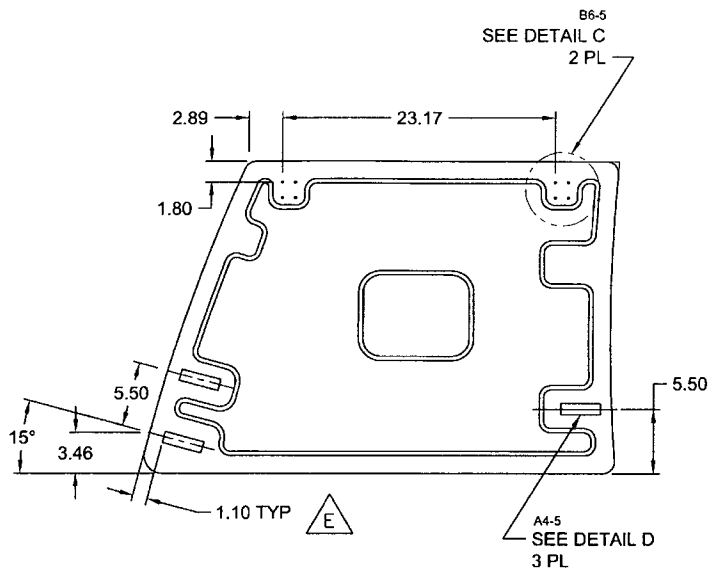
RELEASED
2009-09-09

NOTES:

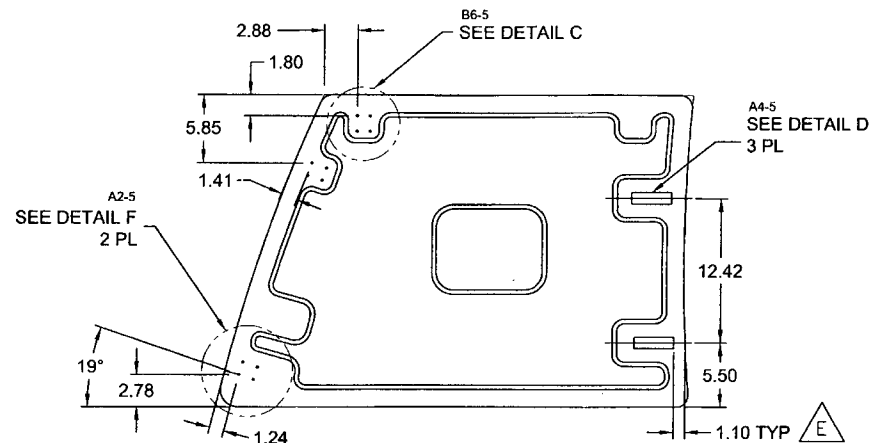
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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NO. 53192
0209110126

| | | | | |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------|--------------|----------|
| E | DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026 | | RF | 09.07.08 |
| D | UPDATE DIMENSIONS | | LE | 07.02.22 |
| C | REMOVED D0600-XXX LABELS | | LE | 06.12.13 |
| B | DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED | | LE | 06.09.25 |
| A | NEW ISSUE | | CP | 03.03.27 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | RF | | | |
| CHECKED |  | DRAWING NO. | REV. E | |
| MFG. APPR. |  | D3186 | SHEET 1 OF 5 | |
| APPROVED |  | TITLE | SCALE | |
| DE APPR. |  | SPACEPOD DOOR | NTS | |
| DATE | 09.07.08 | COPYRIGHT © 2003 BY DART AEROSPACE LTD | | |
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D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M







D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

NOTES:

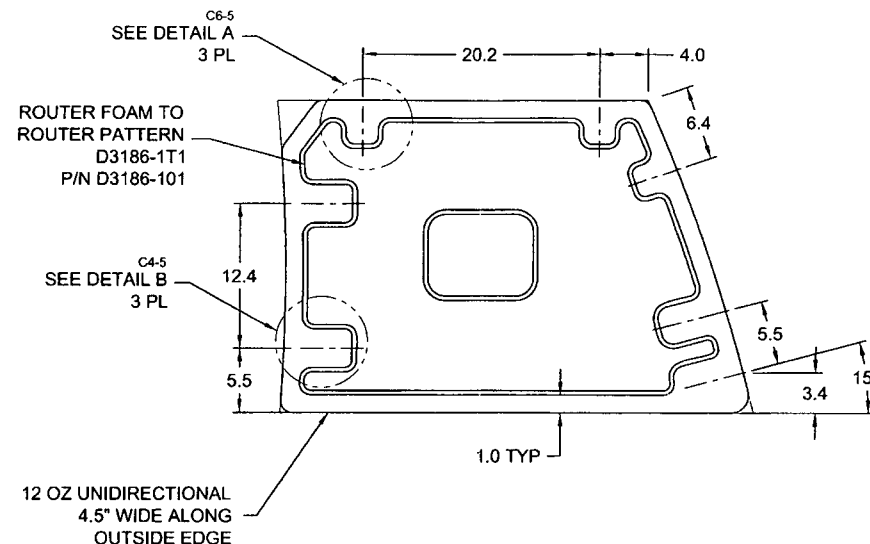
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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2009-09-09

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|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|----------------------------------------|--------------|
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| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. E |
| MFG. APPR. |  | D3186 | SHEET 2 OF 5 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | SPACEPOD DOOR | NT |
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MAIN LAYUP
 9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



D3186-1M SPACEPOD DOOR AS MOLDED

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX





6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

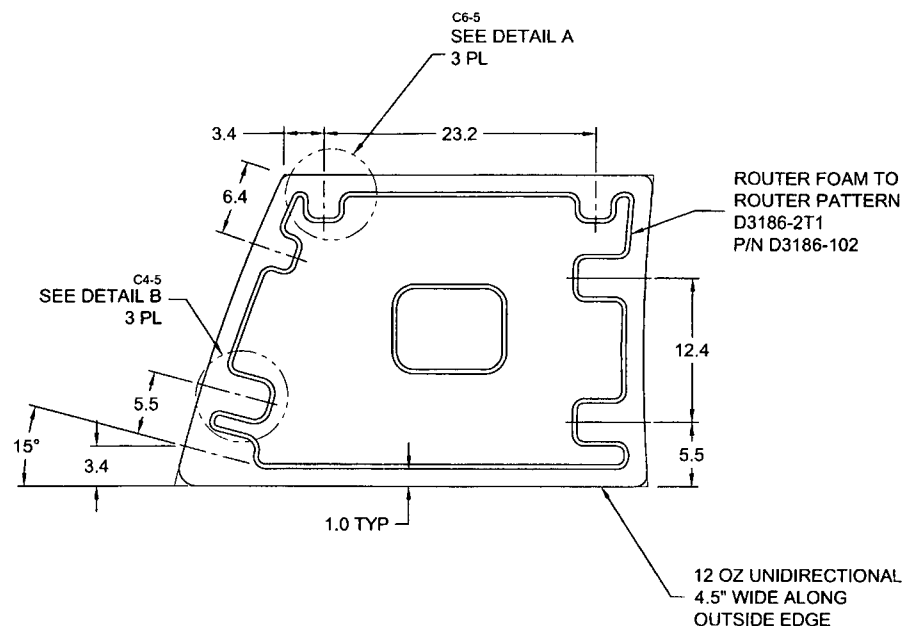
8) USE MOLD DT8005 FOR DOOR LAYUP

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 2009-08-08

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|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|----------------------------------------|--------------|
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| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. E |
| MFG. APPR. |  | D3186 | SHEET 3 OF 5 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | SPACEPOD DOOR | NTS |
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9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



1) MATERIAL:

- RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 7.0 lbs
8) USE MOLD DT8006 FOR DOOR LAYUP

D3186-2M SPACEPOD DOOR AS MOLDED

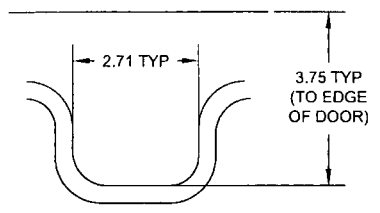
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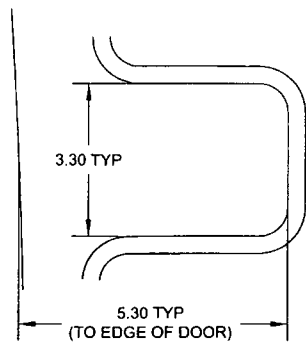
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|---------------|--------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. # |
| MFG. APPR. | <i>[Signature]</i> | D3186 | SHEET 4 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | SPACEPOD DOOR | NT |
| DATE 09.07.08 | | COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. | |

8 7 6 5 4 3 2 1

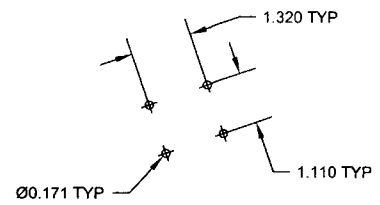
D
C
B
A



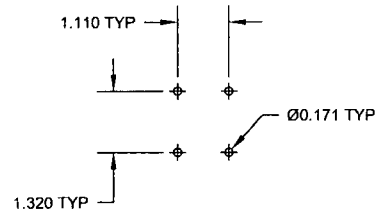
DETAIL A D6-3
SCALE 4X D4-4



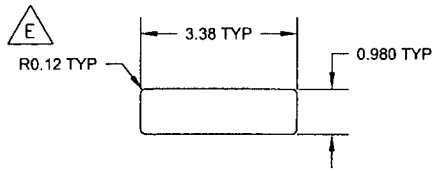
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

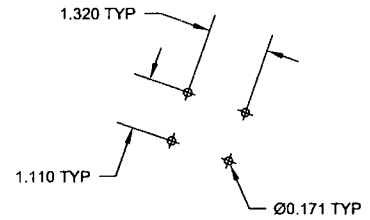


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

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2009-09-09

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WORK ORDER

| | | | |
|------------|----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | | DRAWING NO. | REV. E |
| MFG. APPR. | | D3186 | SHEET 5 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SPACEPOD DOOR | NTS |
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8 7 6 5 4 3 2 1



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SI CERTIFICATE OF COMPLIAN

| | |
|------------|-------|
| Invoice # | 13311 |
| Customer # | DART |

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

| | | | | | | | |
|--------------|------------|---------------|----------------|------------------------------------------------------------------------|-----------------|--------------------------|-----------|
| Ship via | | F.O.B. | | Terms | | Salesperson | |
| PURO COLLECT | | Origin | | Net30 days | | Claude Lessard, ext. 233 | |
| Ship date | Order Date | Our PO # | Order by | | Your PQ # | | GST/PST # |
| 04/02/2010 | 26/10/2009 | 6049 | Chantal Lavoie | | PO10640 REVISED | | |
| Order Qty | B.O. Qty | Current Ship. | Item # | Item Description | | | |
| 1 | 0 | 1 | DKC134-0060 | LINE #3 D31862P Spacepod Door RH B53192 U de M Dwg. Rév.: E | | | |
| | | | | No. lot 43945 Qté 1 | | | |
| 1 | 0 | 1 | DKC134-0071 | LINE #21 D31882P, Spacepod Body RH B53075 U de M Dwg. D3188 Rév.: F | | | |
| | | | | No. lot 23190 Qté 1 | | | |

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357

Priorité 7

DELASTEK COMPOSITES



Date: Mercredi, 2009-11-18 09:20:53
Utilisateur: Claudette Perron



Feuille de Procédé

| | | | |
|-------------------------------------|--------------------------------------|--------------------------|------------------------------|
| Client : | DART Dart Aerospace Ltd. | Nom Dessin : | SPACEPOD DOOR 0. |
| Numéro Job : | 43945 | Numéro Article : | DKC134-0060 |
| Numéro Soumission : | 2610 | Numéro Dessin : | D3186 |
| Numéro B.A. : | | Projet Numéro : | DKC134 |
| Cette fois : | 2009-11-18 | Révision dessin : | D |
| Prsht Rev. : | NC | Matériel : | Fibre 7781 et Résine 411-350 |
| Prem. fois : | - - | Date Dûe : | 2009-11-25 |
| Job précédente : | 43944 | Qté: | 1 Udm: UNITE |
| Écrit par : | | | |
| Vérifié & Approuvé par : | | | |
| Commentaires : | N° de pièce Dart Aerospace : D31862M | | |



Process Sheet Rév.: 02 Modification du planning afin d'y inclure le
N° I.G 0008 (Primer)

Produit additionnel

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|--------------|
| 1.0 | AC0303 | Frekote 44NC |
|-----|--------|--------------|

Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)
Frekote 44NC

| | | |
|-----|---------------|------------------------------|
| 2.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |
|-----|---------------|------------------------------|



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____

| | | |
|-----|--------|---------------------------------|
| 3.0 | AC0409 | Tissu à délaminer Release ply B |
|-----|--------|---------------------------------|

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
Tissu à délaminer Release ply B

| | | |
|-----|--------|------------------------|
| 4.0 | AC0407 | Wrightlon 5200 Bleu P3 |
|-----|--------|------------------------|

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
Wrightlon 5200 Bleu P3

| | | |
|-----|--------|-------------------------------------|
| 5.0 | AC0408 | Feutre de drainage N° Airweave N 10 |
|-----|--------|-------------------------------------|

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Feutre de drainage N° Airweave N 10

| | | |
|-----|--------|----------------------------------|
| 6.0 | AC0752 | Stretchlon 200 poche à vide Vert |
|-----|--------|----------------------------------|

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Stretchlon 200 poche à vide Vert

Date: Mercredi, 2009-11-18 09:20:53
Utilisateur: Claudette Perron

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Numéro Job: 43945

Nom Dessin: SPACEPOD DOOR

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

7.0

AAC0681

9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 4.500 VERGE(s)/Unit Total : 4.500 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

1-26083-1

8.0

AAC0443

Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

9.0

AC0098

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s)

Ruban à gommer jaune #: T/AT-200Y

10.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 11 Jan 10 Heure Début: 10:15 Heure Fin: 10:20 Sceau:



11.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

12.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-26248-1

13.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 19 Jan 10 Heure Début: 10:15 Heure Fin: 10:20 Sceau:



Date: Mercredi, 2009-11-18 09:20:53
Utilisateur: Claudette Perron

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43945

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

14.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: 19 June Heure Début: 07:22 Heure Fin: 10:30 Sceau:



15.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 19 June Heure Début: 10:30 Heure Fin: 10:40 Sceau:



Curing Début: 10:20 Curing Fin: 4:10

16.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-22176-1

17.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-25959-1

Date: Mercredi, 2009-11-18 09:20:53
Utilisateur: Claudette Perron

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43945

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0060

Numéro Job:



Séq.: Machine ou Opération: Description :

18.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heure.

Date: 16/11/09 Heure Début: 16:25 Heure Fin: 10:35 Sceau:

19.0 AAC0452 Polybond B46F

Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)
Polybond B46F N° de Lot: 1-25391-1

20.0 DKC134-0057 Foam Core N° D3186-102 (Porte D3186-2)

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D3186-102 (Porte D3186-2)

N° de Job: 43975

21.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Retirez le bagging.

Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Faire l'inspection du positionnement par le département de la qualité









Date: _____ Sceau: _____ Initiales: _____

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: 16/11/09 Heure Début: 2:20 Heure Fin: 2:35 Sceau:

Date: Mercredi, 2009-11-18 09:20:53
Utilisateur: Claudette Perron

Feuille de Procédé

| | | | |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|--|
| Client: DART Dart Aerospace Ltd. | | Nom Dessin: SPACEPOD DOOR | |
| Numéro Job: 43945 | | Numéro Article: DKC134-0060 | |
| Numéro Job: | |  | |
| # Séq.: | Machine ou Opération: | Description : | |
| 22.0 | POCHE À VIDE 1 | FAIRE LA POCHE À VIDE | |
| |  |  | |
| Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs EFFECTUER LA POCHE A VIDE Faire la poche à vide en appliquant les composantes dans l'ordre suivant: 1- Tissu à délaminer 2- Feutre de drainage 3- Sac à vide Stretchlon 200 Laisser sécher pendant 2 heures minimum. Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) afin d'enlever le surplus de polybond Date: <u>20/11/09</u> Heure Début: <u>2:35</u> Heure Fin: <u>2:45</u> Sceau:   Curing Début: <u>2:20</u> Curing Fin: <u>8:00</u> | | | |
| 23.0 | AAC0275 | Catalyst N° DDM-9 | |
| Commentaire Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-22176-1</u> | | | |
| 24.0 | AAC0324 | Résine (411B7530) 411-350 promo. 75min. | |
| Commentaire Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-26380-1</u> | | | |
| 25.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART | |
| |  |  | |
| Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MATÉRIEL Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350. Date: <u>25-01-10</u> Heure Début: <u>12:35</u> Heure Fin: <u>12:40</u> Sceau:  | | | |

Date: Mercredi, 2009-11-18 09:20:53
Utilisateur: Claudette Perron

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43945

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0060

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|-----------|---------------------|
| 26.0 | LAMINAGE. | LAMINAGE PIÈCE DART |
|------|-----------|---------------------|



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: 25 Nov 10 Heure Début: 12:40 Heure Fin: 1:10 Sceau:



| | | |
|------|----------------|-----------------------|
| 27.0 | POCHE À VIDE 1 | FAIRE LA POCHE À VIDE |
|------|----------------|-----------------------|



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 25 Nov 10 Heure Début: 1:10 Heure Fin: 1:25 Sceau:



Curing Début: 12:40 Curing Fin: 8h20

| | | |
|------|-------------|----------------------|
| 28.0 | DÉMOULAGE 1 | DÉMOULAGE PIÈCE DART |
|------|-------------|----------------------|



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE DES PIECES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le le moule afin d'éliminer le fini lisse de celui-ci.

Date: 26-01-10 Heure Début: _____ Heure Fin: _____ Sceau:



Date: Mercredi, 2009-11-18 09:20:53
Utilisateur: Claudette Perron

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43945

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

29.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer les contour de la pièce l'aide du gabarit de trimage prévu à cet effet.

Date: 26-01-10 Heure Début: 8h00 Heure Fin: 9h00 Sceau:



30.0

AAC0683

Dupont Primer N° 7704S

Commentair Qty.: 0.1390 UNITE(s)/Unit Total : 0.1390 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 2-25612-2

31.0

AAC0685

Dupont Activator - Reducer Chromabase N° 7775S

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
Dupont Activator - Reducer Chromabase N° 7775S

2-24803-3

32.0

PRIMER

APPLICATION DE PRIMER



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 27/01/10 Sceau:



Quantité: 1 Date: 29/01/10 Sceau:



Quantité: 1 Date: 01/02/10 Sceau:



Quantité: 1 Date: 03/02/10 Sceau:



33.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
INSPECTION PIÈCE DART

Inspection des pièces par le département de la qualité

Quantité: 1 Date: 4-2-10 Sceau:



Quantité: _____ Date: _____ Sceau: _____

Date: Mercredi, 2009-11-18 09:20:53
Utilisateur: Claudette Perron

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43945

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

34.0


EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 4-2-10 Sceau: 

Quantité: _____ Date: _____ Sceau: _____